

# Work Order ID 59826

Friday, June 11, 2010 12:58:22 PM



Page 1

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 6/11/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *R*

Date: *10-6-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3255	Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 \*\*\*purge weld\*\*\* ☐ A/R SS ROD  
Batch: *M108160* ☐ 2-Grind Welds Flush

*EL 10-6-30* *(st)*

110

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*8/10/06/30*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/06/30*

*(st)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59826**

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Item ID: D3255-041

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Start Date: 6/11/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>9:15</i> <i>3200</i> <input type="checkbox"/> FINISH TIME: <i>9:45</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>2</i> <i>10/07/07</i>	0.00 0.00							
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>10/07/07</i>			<i>2</i>	<i>4</i>	
150  Small Fab Small Fab	Small Fab Memo 1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255 <input type="checkbox"/> A/R 736 DOW CORNING ADHESIVE Batch: <i>M11418</i> <i>2</i> <i>10/07/12</i>	0.00 0.00					<i>2</i>		

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 59826**

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Item ID: D3255-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/11/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/12

(+2)

-041

170

Identify as per dwg &amp; Stock Location: 176

0.00



Packaging

Memo

0.00

Packaging

10-7-12 5/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-12 5/10  
2

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 11, 2010 12:58:26 PM

Page 1

Work Order ID: 59826

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1 Panel		Manufactured	No			100	Each	7.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA	46857			7					
								7					
D3255-5 Gasket		Manufactured	No			100	Each	8.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST047	48540			8					
								8					
D3255-3 Cap		Manufactured	No			150	Each	19.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA	48315			19					
								19					

CL 10-6-30

2

2 SN 10/07/12

CL 10-6-30

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

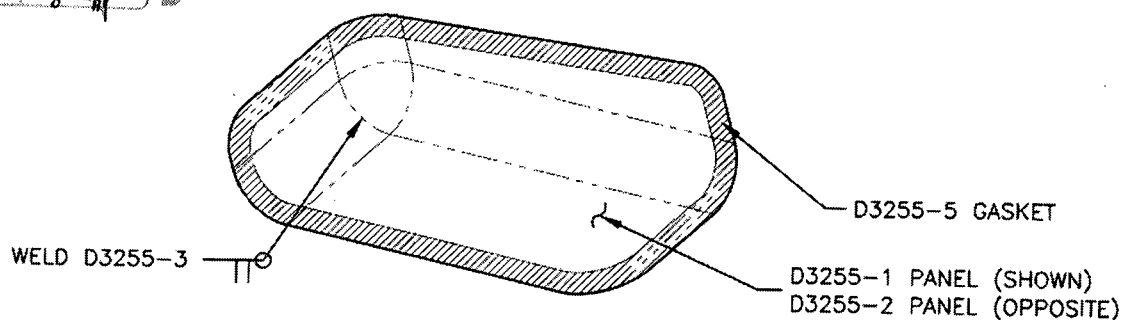
**NOTE:** Date & initial all entries



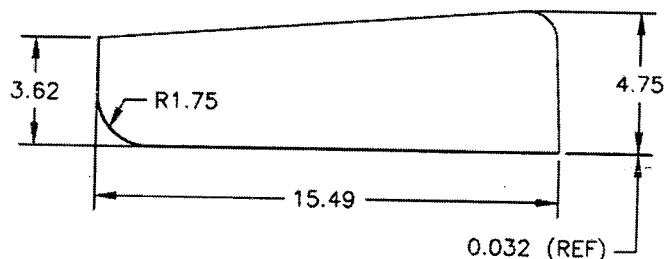
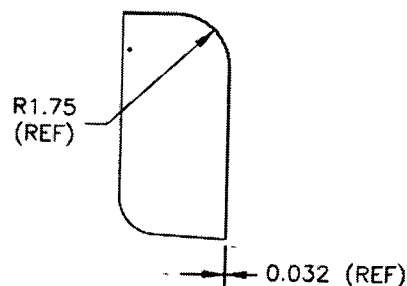
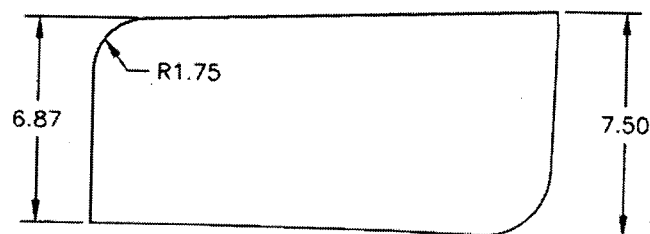


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CHECKED <i>if</i>	APPROVED <i>if</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05.01.18 *if*



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *59826*  
*11/06/11*

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

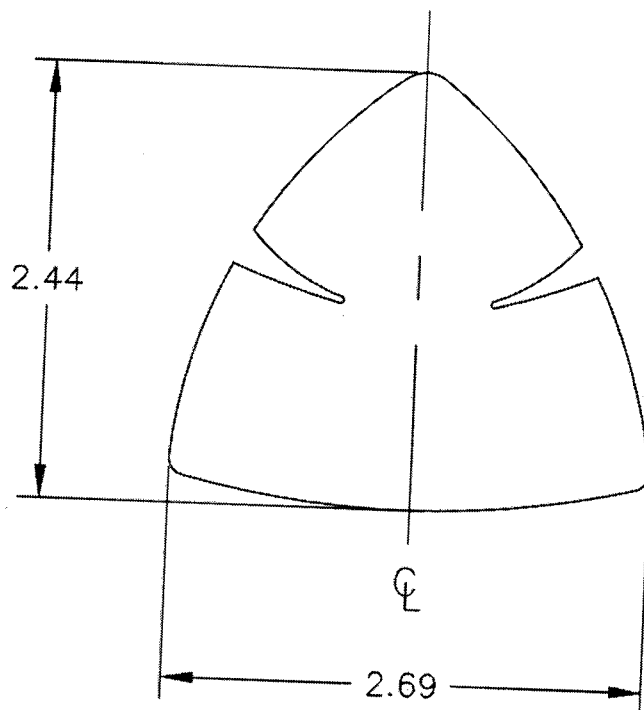
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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED 4P	APPROVED [Signature]	DRAWING NO. D3255	REV. B
DATE 04.12.06		TITLE TITLE	SHEET 2 OF 4 SCALE 1:1

RELEASED  
05-01-18 #



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

w/o 59824

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

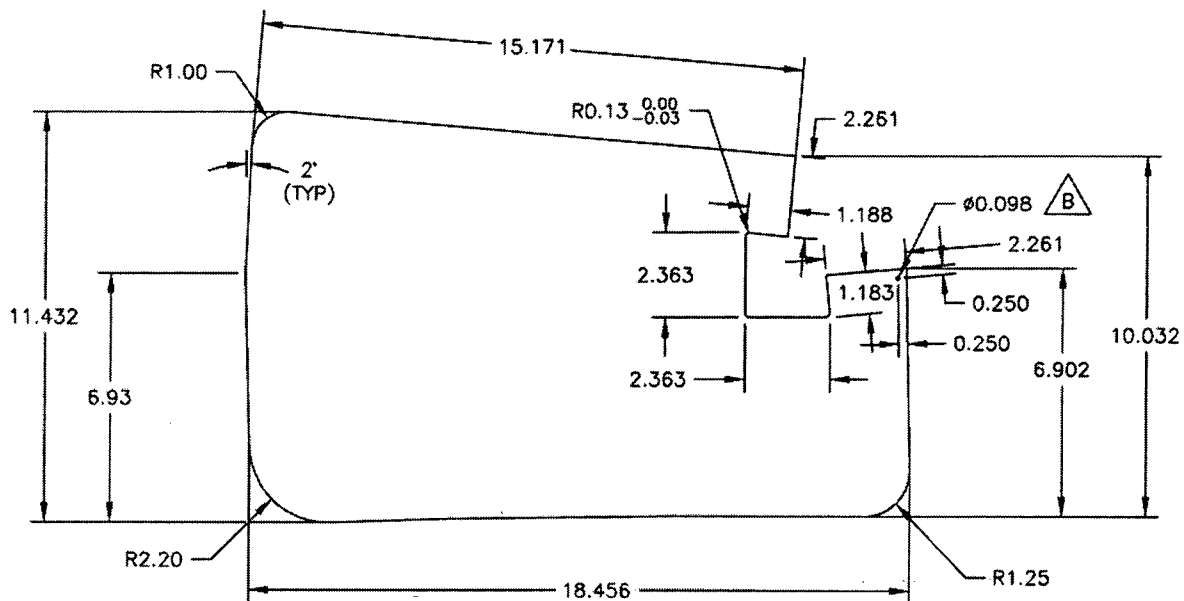
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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**RELEASED**  
05-01-18 [Signature]**D3255-1/-2 FLAT PATTERN**

w/o 59824

**D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

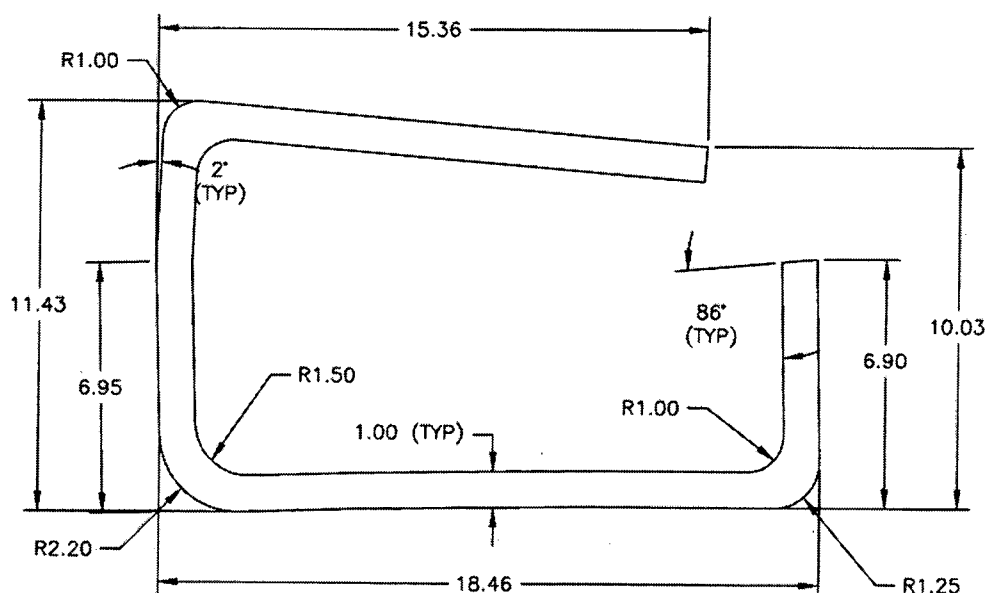
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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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CHECKED UP	APPROVED JT	DRAWING NO. D3255	REV. 8 SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
DS 01.18 #



**D3255-5 GASKET**

W/C 59520

**D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS-3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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